

Work Order ID 63267



Page 1

Wednesday, October 27, 2010 9:06:00 AM

Item ID: D212-725-1-127F

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset

Start Date: 10/27/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: H

Date: 10-10-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D212-725-1

Rev G

100

0.00



Waterjet

Memo

0.00

18-10-10-28

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: G

Prog Rev: G

304 .040

2-Deburr if necessary

Q

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

18-10-10-29

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(+2)			
130  Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00				(2)			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(+2) -127			

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Page 3

Item ID: D212-725-1-127F

Accept

Revision ID:

Item Name: Gusset

Start Date: 10/27/2010 Start Qty: 2.00

Required Date: 11/30/2010 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>388</u> Memo	0.00 0.00							

u/a
Parts are made of stainless steel
Solulps

Ceryls (2)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 63267

Wednesday, October 27, 2010 9:06:00 AM

Page 4

Item ID: D212-725-1-127F

Accept

Setup Start

Revision ID:

Stop

Item Name: Gusset

Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/29 J

10-10-28

2

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 27, 2010 9:06:05 AM

Page 1

Work Order ID: 63267



Parent Item: D212-725-1-127F



Parent Item Name: Gusset


Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	166.2000	0.1119	0.235579			



18 10-10-28

Location

Loc Qty

Loc Code

MAT

162.2

115762

10.2

115953

152

MAT20

4

113062

1.398

115440

2.602

115953

(2)

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

0212-705-1-127 F

X	First Article	X	Prototype
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Measured by:	VB
Date:	10-10-29

Audited by:	S
Date:	10/10/28

Prototype Approval:	
Date:	

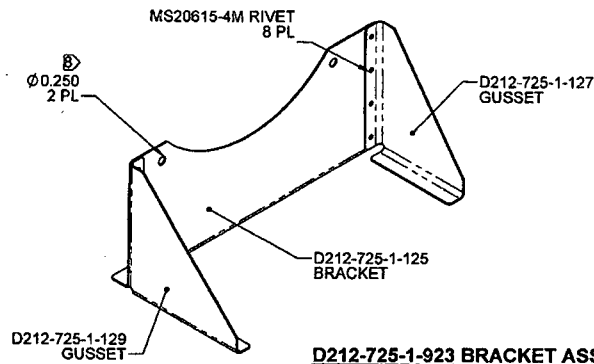
H:\FORMS\Quality Assurance\approved QA\FAI revD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

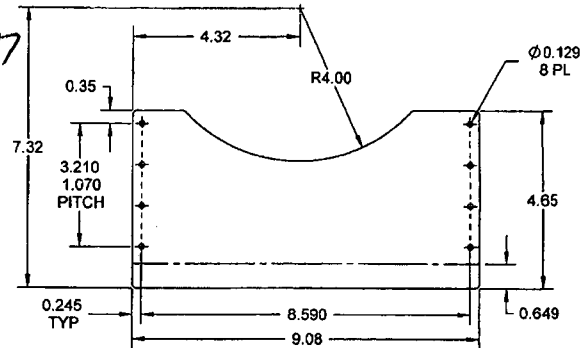
WITHOUT NOTICE
WORK ORDER

NO. 93247

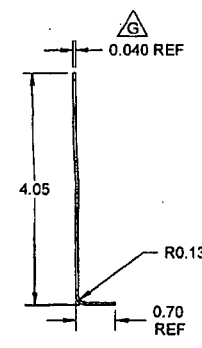
BS10-1027



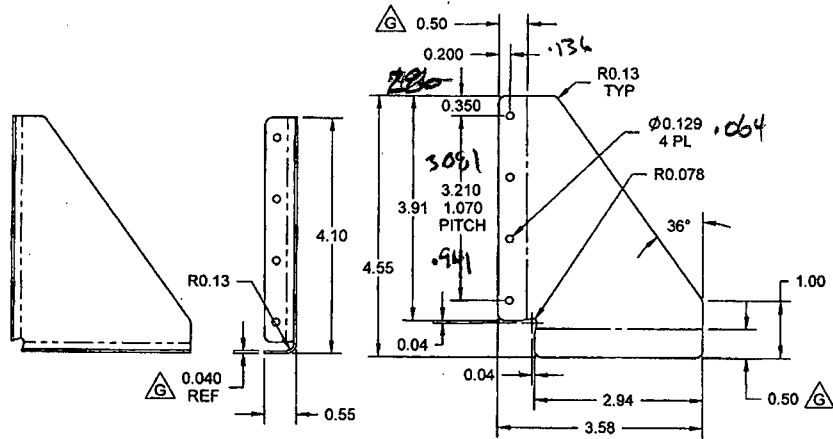
D212-725-1-923 BRACKET ASSEMBLY



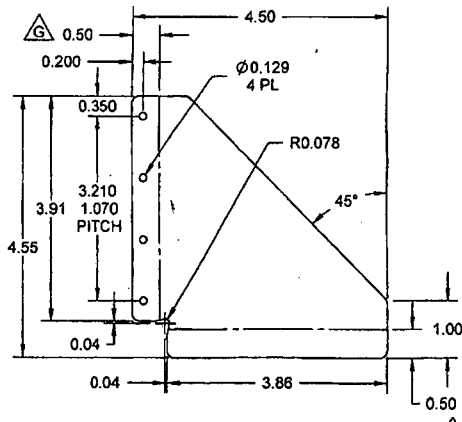
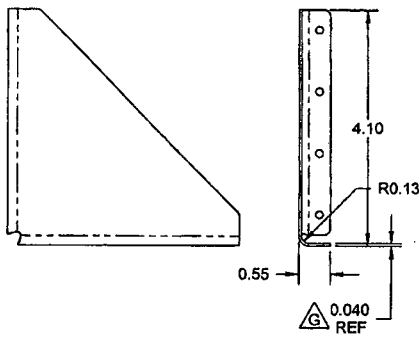
D212-725-1-125F FLAT PATTERN



D212-725-1-125 BRACKET
(MAKE FROM D212-725-1-125F FLAT PATTERN)



D212-725-1-127F FLAT PATTERN



D212-725-1-129F FLAT PATTERN

D212-725-1-127 GUSSET
(MAKE FROM D212-725-1-127F FLAT PATTERN)

D212-725-1-129 GUSSET
(MAKE FROM D212-725-1-129F FLAT PATTERN)

RELEASED

BS10-1027

- D212-725-1-125/-127/-129 NOTES:**
- 1) MATERIAL: AISI 304 STAINLESS STEEL ANNEALED 2B FINISH SHEET 0.040 (19 GAUGE) THICK PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 REF DART SPEC M304S19GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY ASSEMBLY WITH DART P/N D212-725-1-923 USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: N/A
 - 8) TRANSFER Ø0.250 HOLES FROM FIRE EXTINGUISHER BOTTLE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. G
MFG. APPR.	RF	D212-725-1	SHEET 41 OF 84
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	212S DETAIL PARTS	NTS
DATE	10.02.12	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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